



Work Order ID 60958

July 29, 2010 11:03:33 AM


Page 1

PRELIMINARY ISSUE

Item ID: D4055-043 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Aux Tank
 Start Date: 7/29/10 Start Qty: 1.00  Cust Item ID:
 Required Date: 7/30/10 Req'd Qty: 1.00  Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4055	AB								

100  0.00
 Large Fab
 Large Fab

Memo
 MODIFY AS PER DRWG D4055 REV.B
 DETAIL -043 D4055-041
 - Weld tabs D4124-1 per Dwg.
 - Weld sump D4125-041 per Dwg.
 - Instal tank support D4062-1 per Dwg.

BS6762
 10/07/29 (14)
 10-07-29
 100803

QC 9 inspect weld. → BE 10/08/03
 QC 5 inspect work to current →
 step. S10/08/03 / 10/08/03

POSITIVE RECALL
 EFFECTIVE 10/07/29 AUTH
 RELEASED _____ DATE _____

Confirmitly test. 10.07.30
 Rev.B with Series Deviation

Picklist Print

Page 1

July 29, 2010 11:03:25 AM

Work Order ID: 60958

Parent Item: D4055-043

Parent Item Name: Aux Tank









Start Date: 7/29/10

Required Date: 7/30/10

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4062-1 		Manufactured	No				Each	0.0000		1		10 07 29	
Tank Support	B 60766												
✓ D4124-1 		Manufactured	No				Each	0.0000		1		10 07 29	
Tab	B 60740												
✓ D4125-041 		Manufactured	No				Each	0.0000		1		10 07 29	
Fwd Sump Assembly	B 60738												
MS21042L3 		Purchased	No				Each	2,472.000		6			
Nut	M 114718												

Location

Loc Qty

Loc Code

ST300

2472

114523

115

114718

357

114784

2000

MS27039-1-22

M 18057

MS35206-250

Purchased

No

Each

0.0000

6



Screw



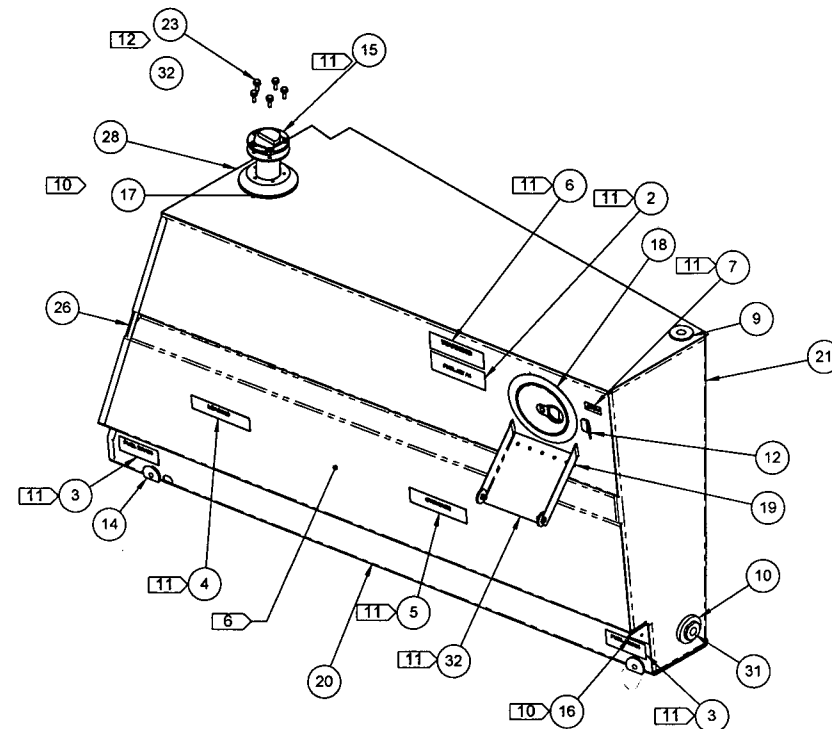
NAS 1149 D0363J

M 115107

6 10 07 29 ~~10~~

6 10 07 29 ~~10~~

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-9	ANGLE
9	1	D4000-5	FUEL TANK VENT FITTING
10	1	D4000-1	FUEL SUPPLY FITTING
11	3	D4000-9	GROMMET
12	1	D3999-11	EARTH TAB
13	1	D4000-043	AFT FUEL SUMP DRAIN ASSEMBLY
14	1	D4000-045	FORWARD FUEL SUMP DRAIN ASSEMBLY
15	1	D4025-1	FUEL SENDER
16	1	D3999-7	CORNER
17	1	D4001-1	FITTING
18	1	D4023-1	FUEL CAP
19	1	D4008-11	TANK HINGE HALF
20	1	D4055-11	TANK FRONT AND BOTTOM
21	1	D4055-3	TANK AFT END
22	3	D4057-1	RETAINING RING
23	5	AN3H5A	BOLT
24	5	NAS1149D0363J	WASHER
25	1	D4055-9	TANK BACK
26	1	D4055-7	TANK FORWARD END
27	1	D4055-5	TANK UPPER CUT OUT
28	1	D4055-1	TANK TOP
29	1	D3999-041	BAFFLE ASSEMBLY, AFT
30	1	D3999-043	BAFFLE ASSEMBLY, FWD
31	1	D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
32	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY



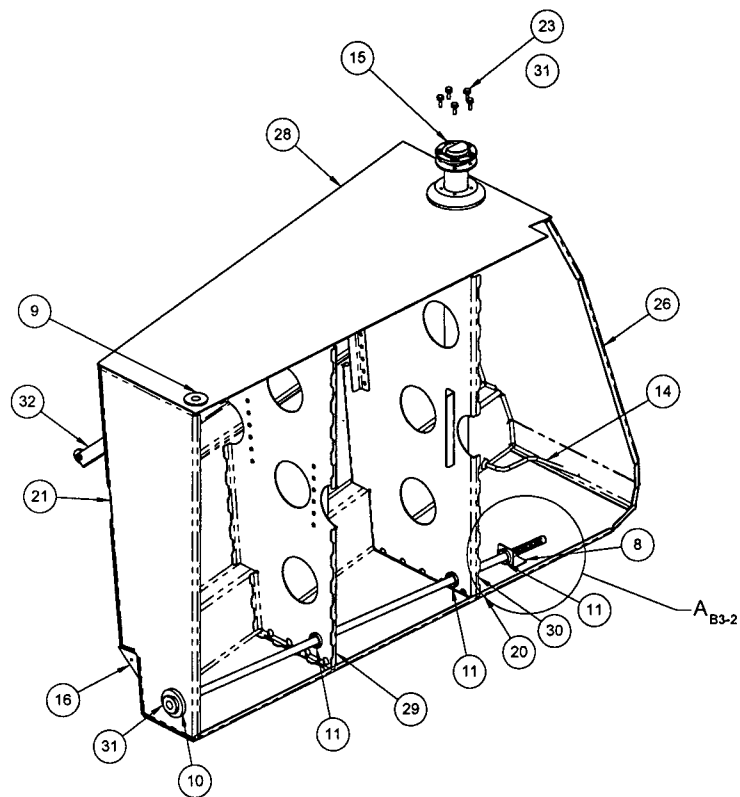
D4055-041 AUX TANK

NOTES:

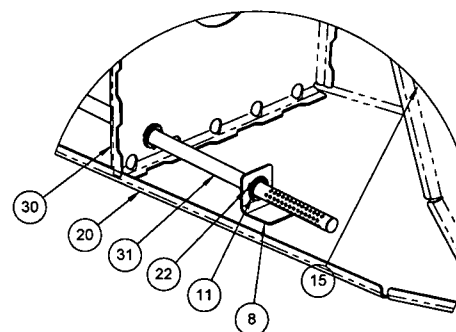
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT
- 12) LOCKWIRE BOLTS AFTER INSTALLATION

B	ADD -043 ASSEMBLY (SHT 5-7) AND -13 PART (SHT 19-20)	10.07.26
A	NEW ISSUE	10.04.16
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.07.26	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B
TITLE TANK	SHEET 1 OF 20
SCALE NTS	
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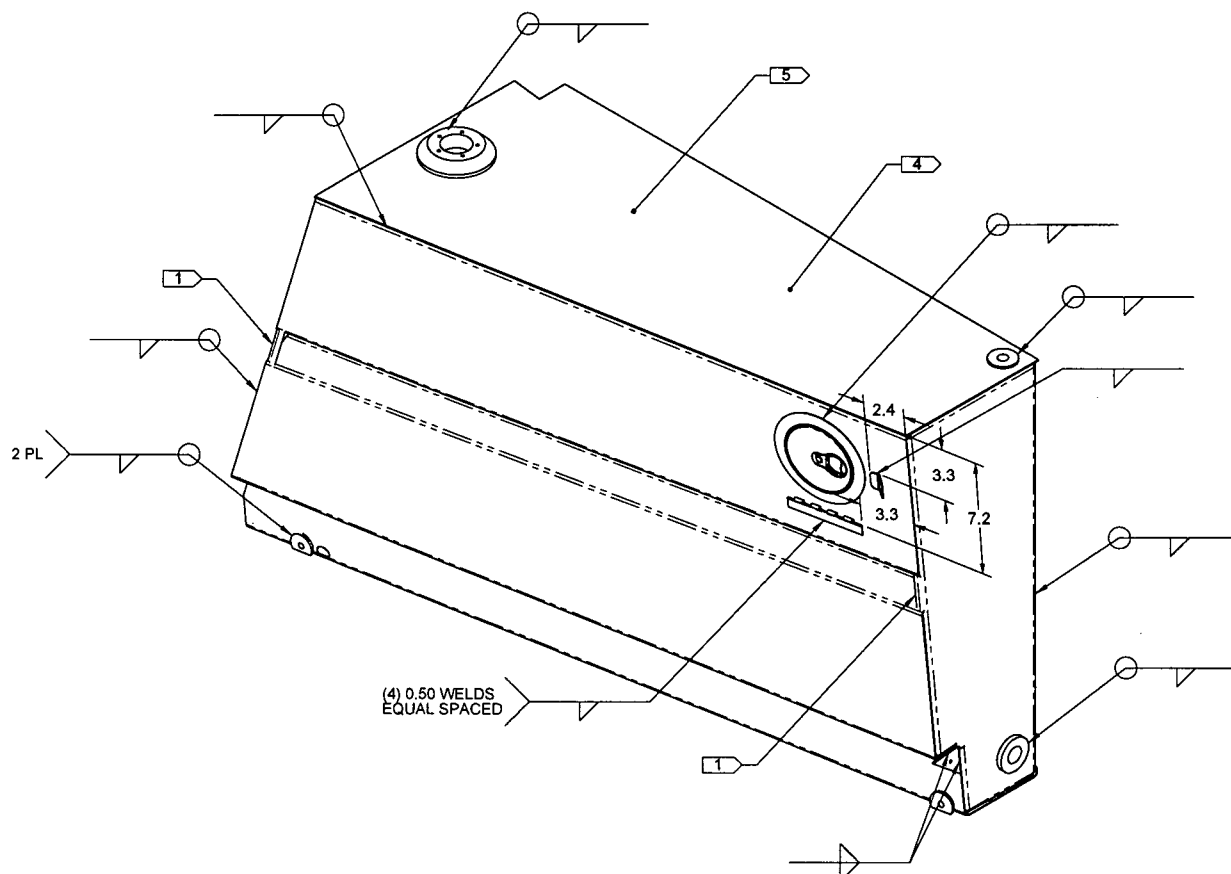


D4055-041 AUX TANK
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A B3-2
ROTATED FOR CLARITY
SCALE: 2X

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	EE	D4055	SHEET 2 OF 20
APPROVED	140	TITLE	SCALE
DE APPR.		TANK	NTS
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D4055-041 AUX TANK
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED:
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH FUEL TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH) SLOSHING SEALER. ENSURE FILTERS, FITTINGS AND SENDER UNITS ARE REMOVED AFTER WELDING
- 4) ACCEPTABLE TO DRILL 6 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) Ø0.312 HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 3 OF 20
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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8 7 6 5 4 3 2 1

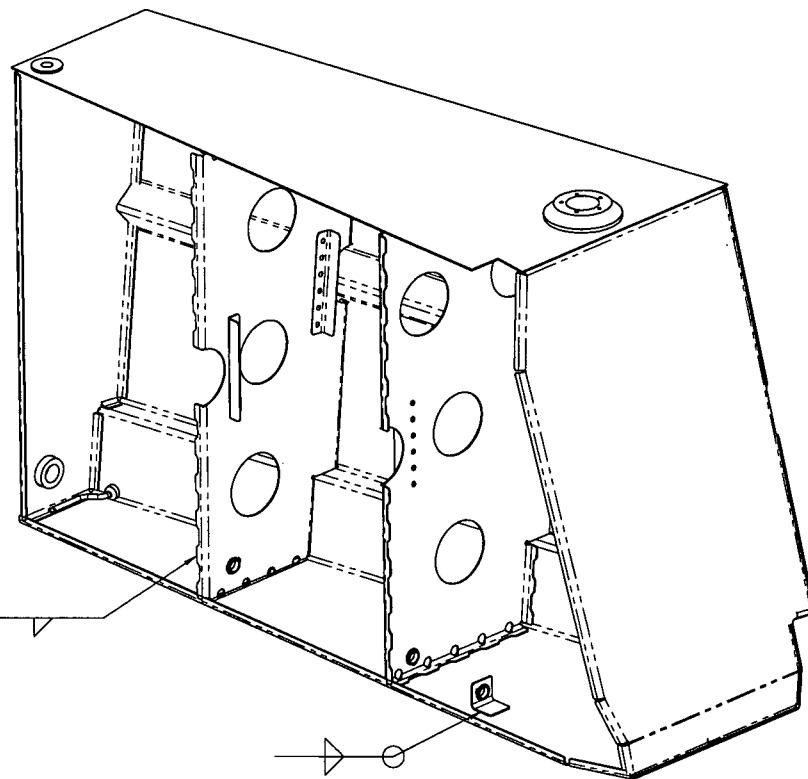
D

C

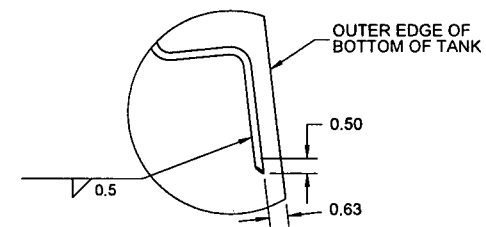
B

A

WELD ALL TABS



D4055-041 AUX TANK
WELDING DETAIL



DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>FE</i>	D4055	SHEET 4 OF 20
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.		TANK	NTS
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8 7 6 5 4 3 2 1

D

C

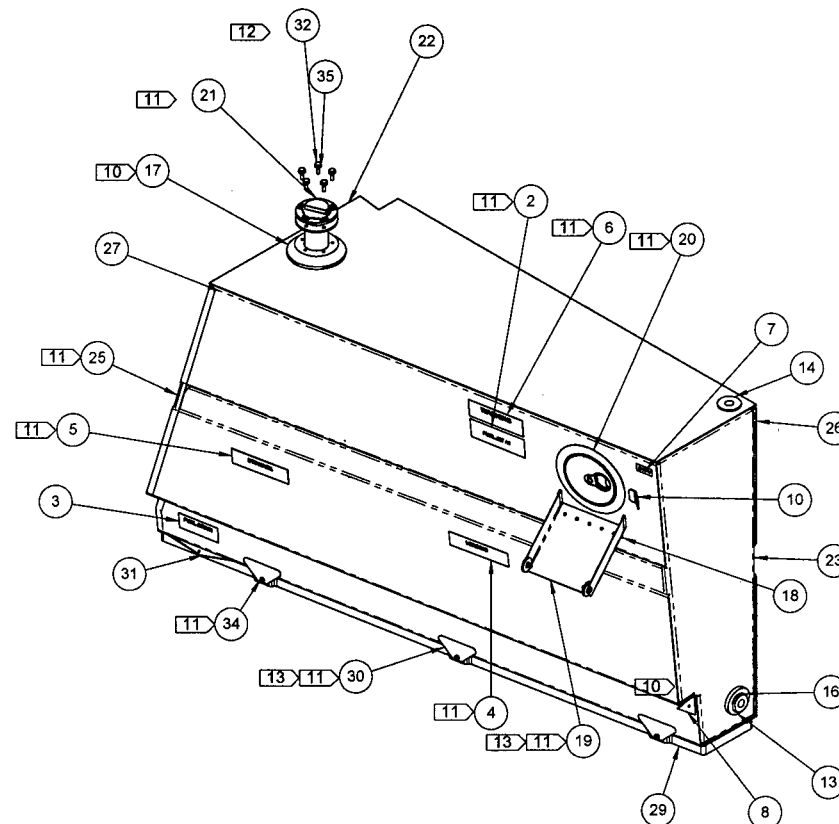
B

A

ITEM NO.	QTY. -041	Partno	DESCRIPTION
1	X	D4055-043	FUEL TANK ASSEMBLY
2	1	✓ D3997-1	PLACARD "FUEL JET A1"
3	1	✓ D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	✓ D3997-11	PLACARD "LOADING"
5	1	✓ D3997-17	PLACARD "STOWAGE"
6	1	✓ D3997-29	PLACARD "WARNING"
7	1	✓ D3997-43	PLACARD "EARTH"
8	1	✓ D3999-7	CORNER
9	1	✓ D3999-9	ANGLE
10	1	✓ D3999-11	EARTH TAB
11	1	✓ D3999-041	BAFFLE ASSEMBLY, AFT
12	1	✓ D3999-043	BAFFLE ASSEMBLY, FWD
13	1	✓ D4000-1	FUEL SUPPLY FITTING
14	1	✓ D4000-5	FUEL TANK VENT FITTING
15	3	✓ D4000-9	GROMMET
16	1	✓ D4000-047	FUEL PICK UP AND STRAINER ASSEMBLY
17	1	✓ D4001-1	FITTING
18	1	✓ D4008-11	TANK HINGE HALF
19	1	✓ D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
20	1	✓ D4023-1	FUEL CAP
21	1	✓ D4025-1	FUEL SENDER
22	1	✓ D4055-1	TANK TOP
23	1	✓ D4005-3	TANK AFT END
24	1	✓ D4055-5	TANK UPPER CUT OUT
25	1	✓ D4055-7	TANK FORWARD END
26	1	✓ D4055-9	TANK BACK
27	1	✓ D4055-11	TANK FRONT AND BOTTOM
28	3	✓ D4057-1	RETAINING RING
29	1	✓ D4062-1	TANK SUPPORT
30	6	✓ D4124-1	TAB
31	1	✓ D4125-041	FWD SUMP
32	5	✓ AN3H5A	BOLT
33	6	✓ MS21042L3	NUT
34	6	✓ MS35206-250	SCREW
35	11	✓ NAS1149D0363J	WASHER

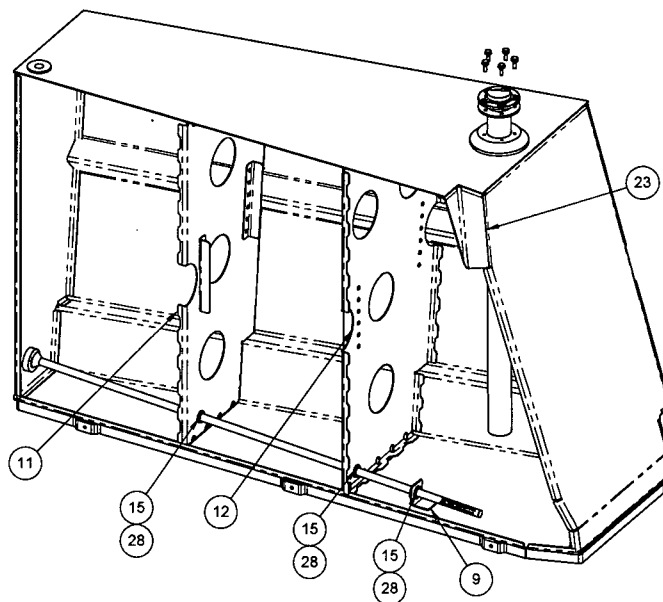
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-143" USING D2729-1 RED DECAL
- 7) WEIGHT: 20.45 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS.
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT
- 12) LOCKWIRE BOLTS AFTER INSTALLATION
- 13) IT IS PERMISSIBLE TO HAND FORM THE TABS (30) AS NECESSARY TO INSTALL THE TANK SUPPORT (29)

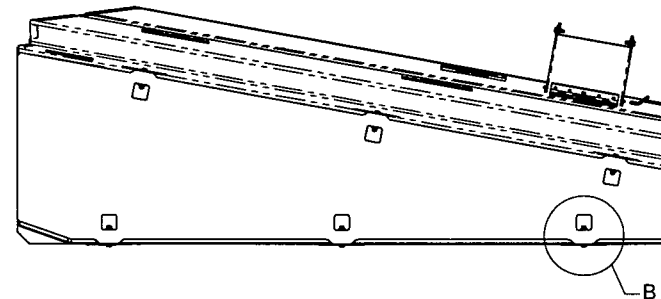


D4055-043 FUEL TANK ASSEMBLY

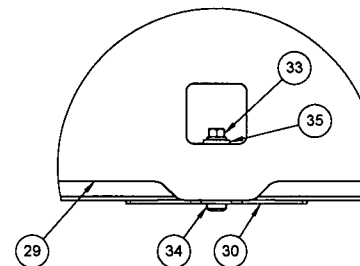
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DRAWN	15	HAWKESBURY, ONTARIO, CANADA	
CHECKED	17	DRAWING NO.	REV. B
MFG. APPR.	18	D4055	SHEET 5 OF 20
APPROVED	140	TITLE	SCALE
DE APPR.		TANK	NTS
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D4055-043 AUX TANK
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL

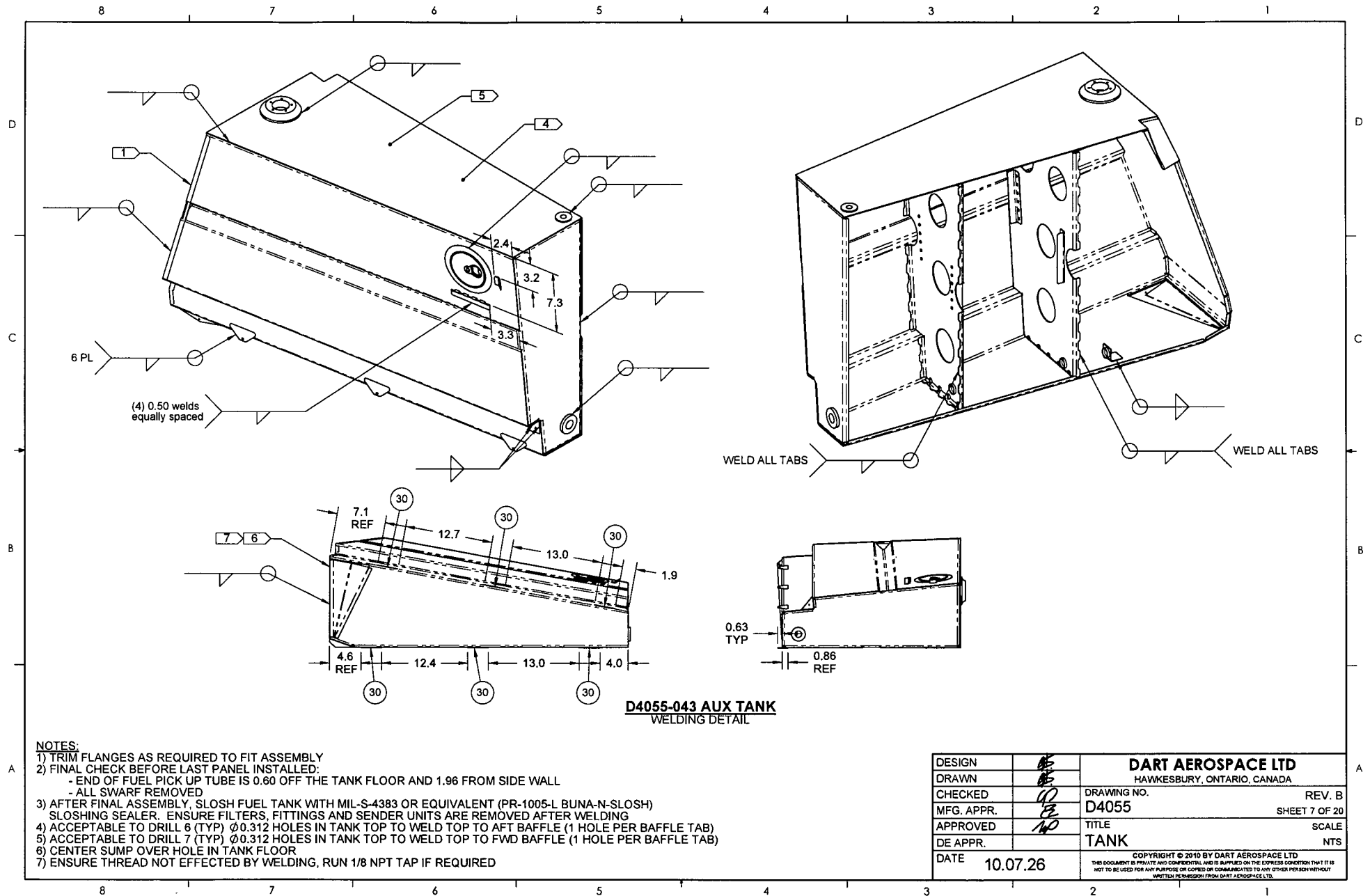


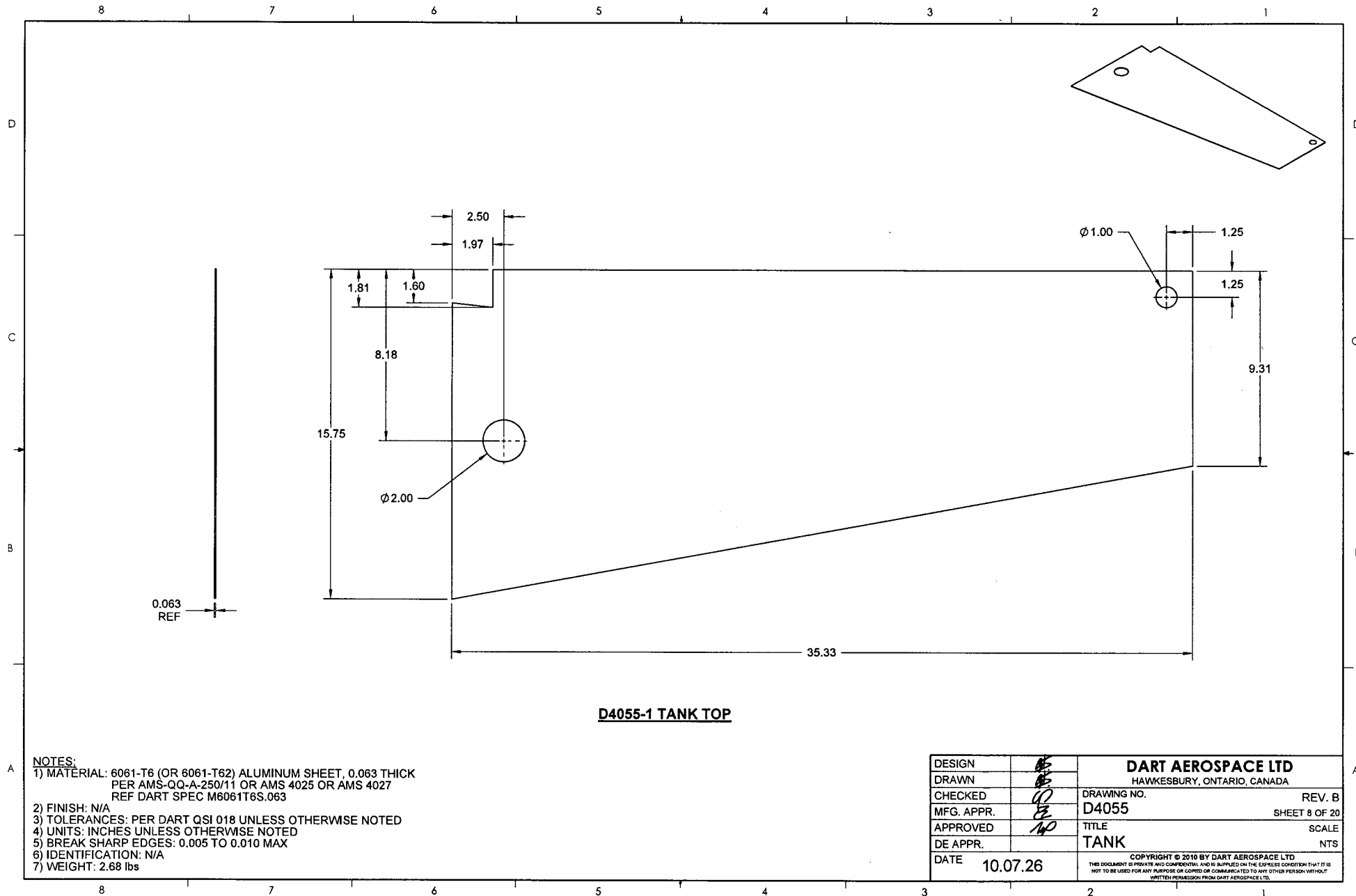
D4055-043 AUX TANK
D4062-17-3/-5 TANK SUPPORT
INSTALLATION

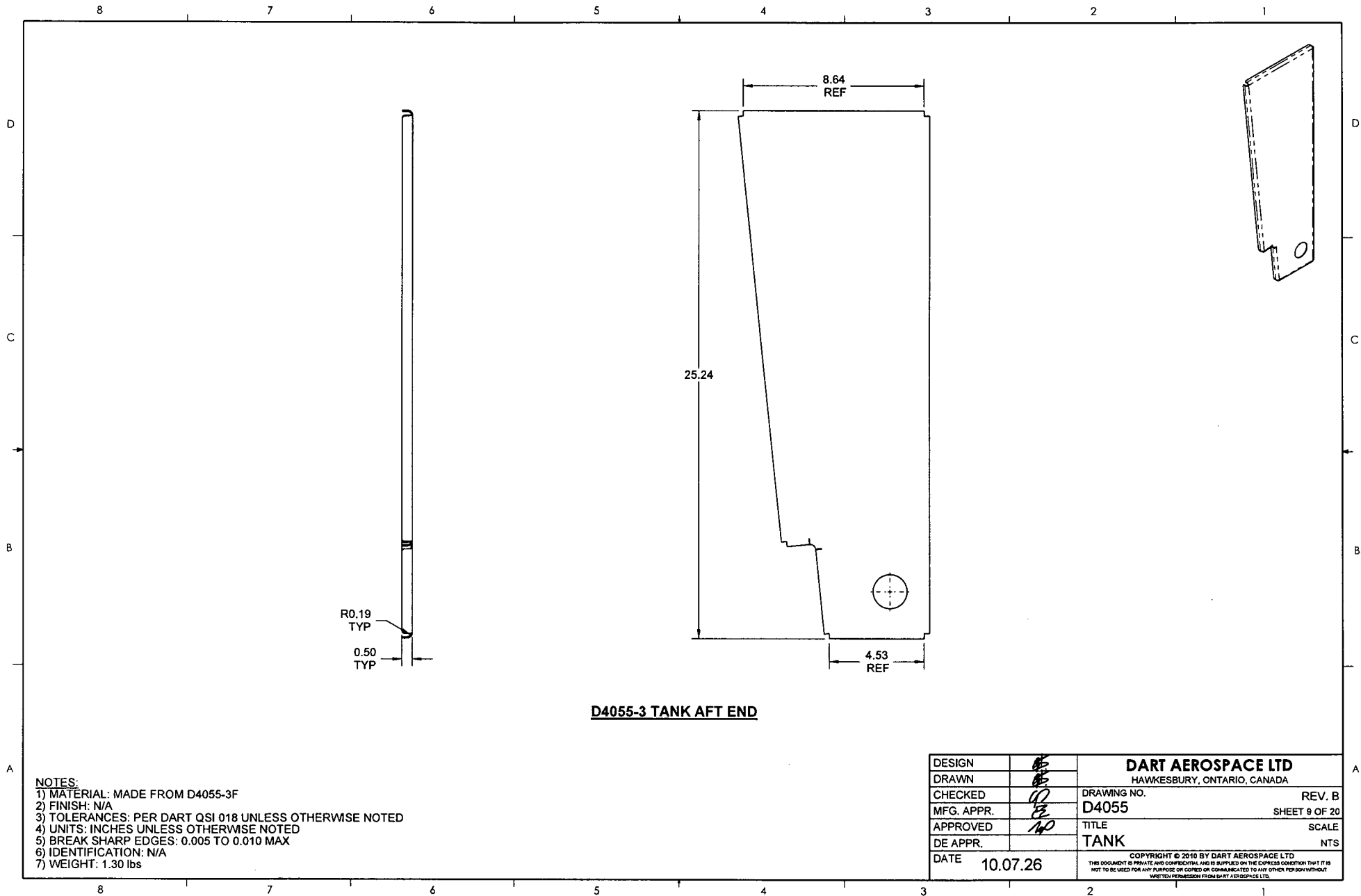


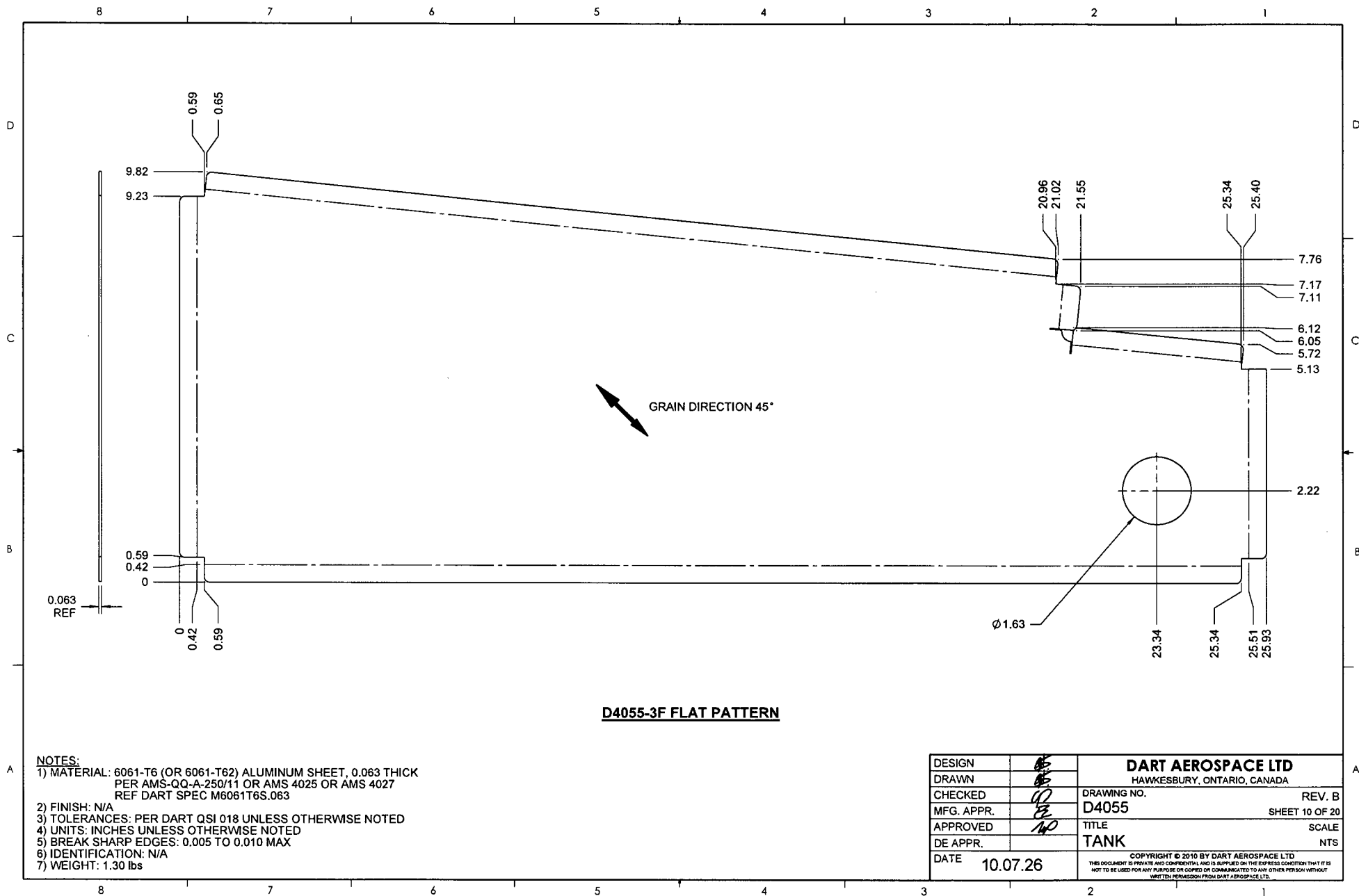
DETAIL B
SCALE 4X
TANK SUPPORT ATTACHMENT, TYP

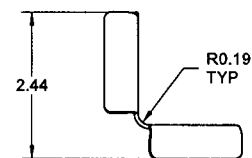
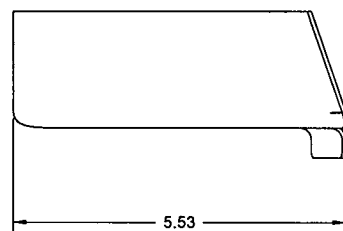
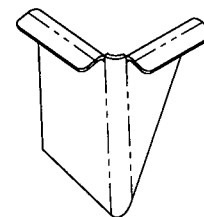
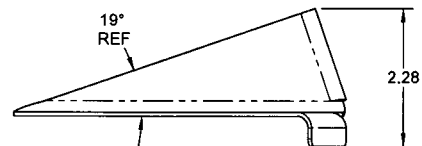
DESIGN	<i>AB</i>	DART AEROSPACE LTD	
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>17</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>12</i>	D4055	SHEET 6 OF 20
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.		TANK	NTS
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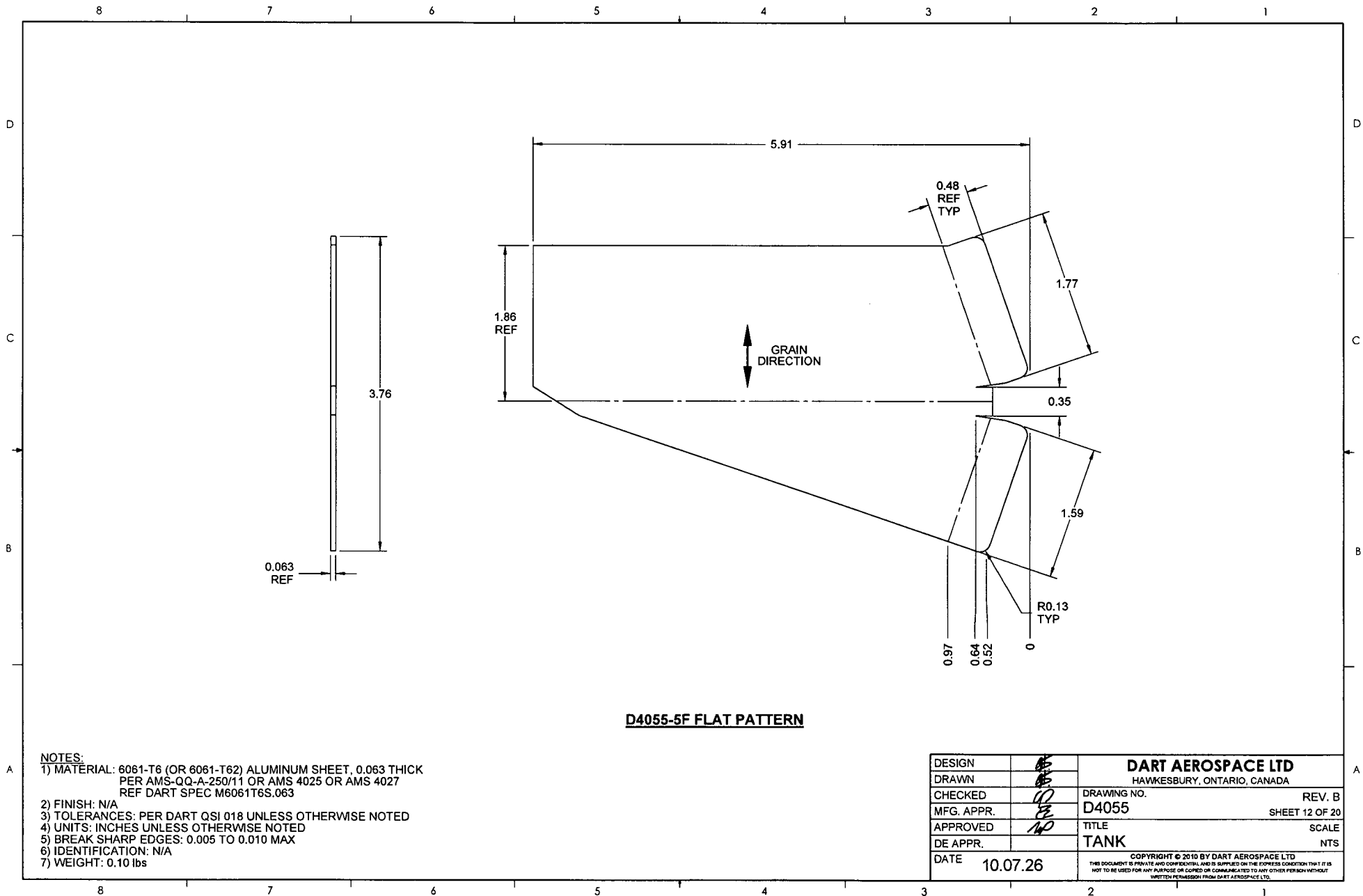


D4055-5 UPPER CUT OUT

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN	<i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>AB</i>		
CHECKED	<i>CD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>EE</i>	D4055	SHEET 11 OF 20
APPROVED	<i>NO</i>	TITLE	SCALE
DE APPR.		TANK	NTS
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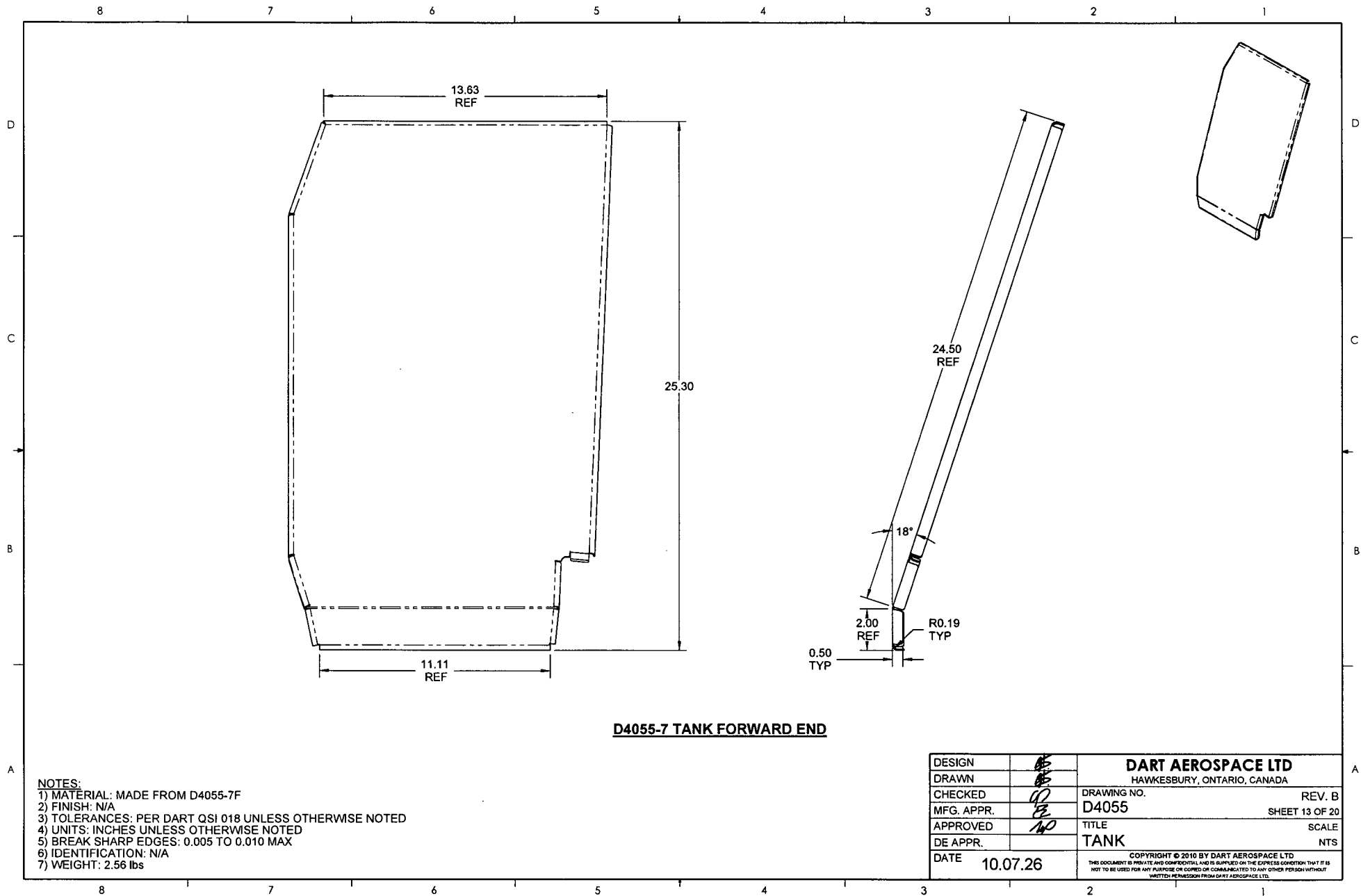


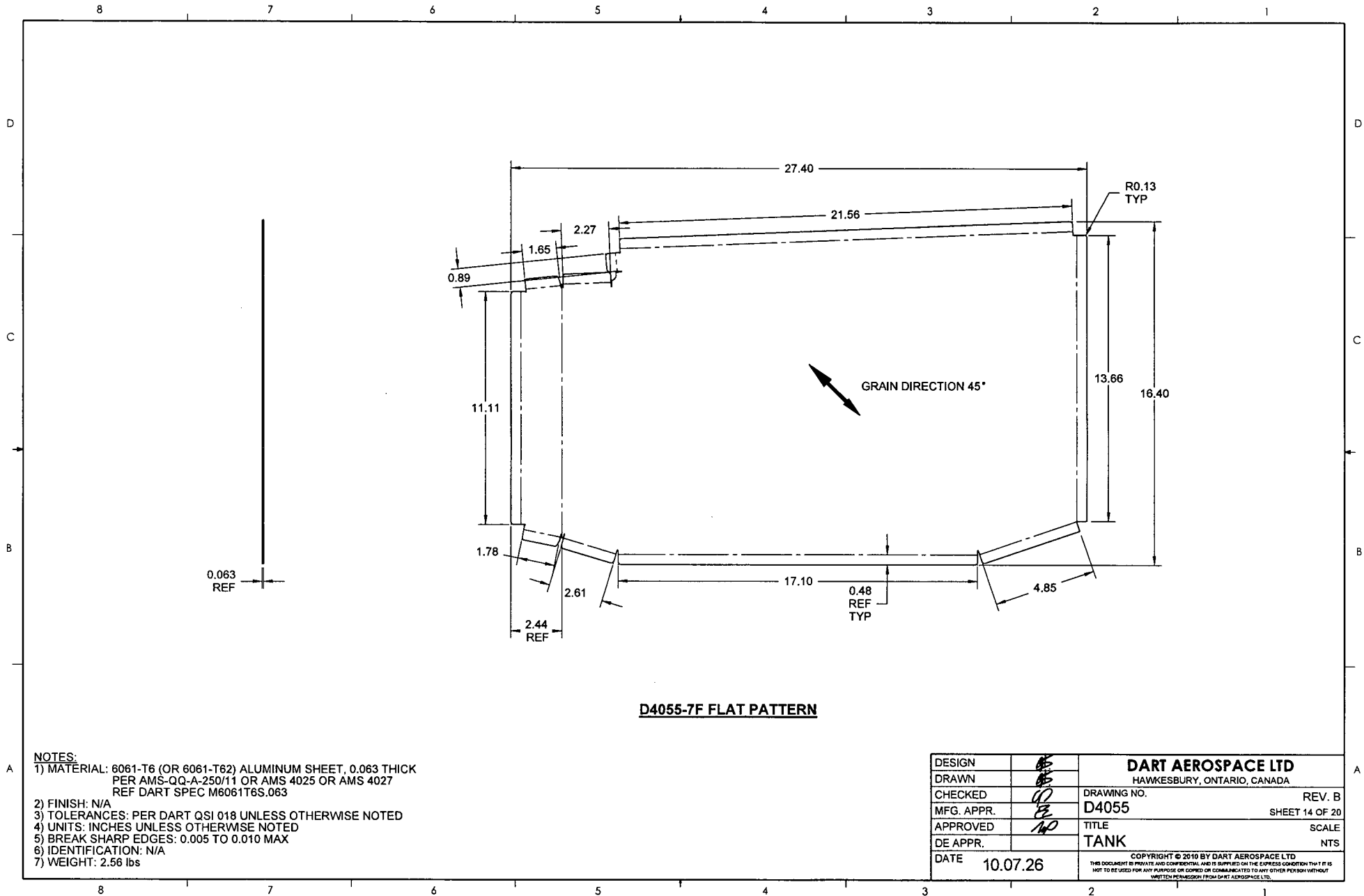
D4055-5F FLAT PATTERN

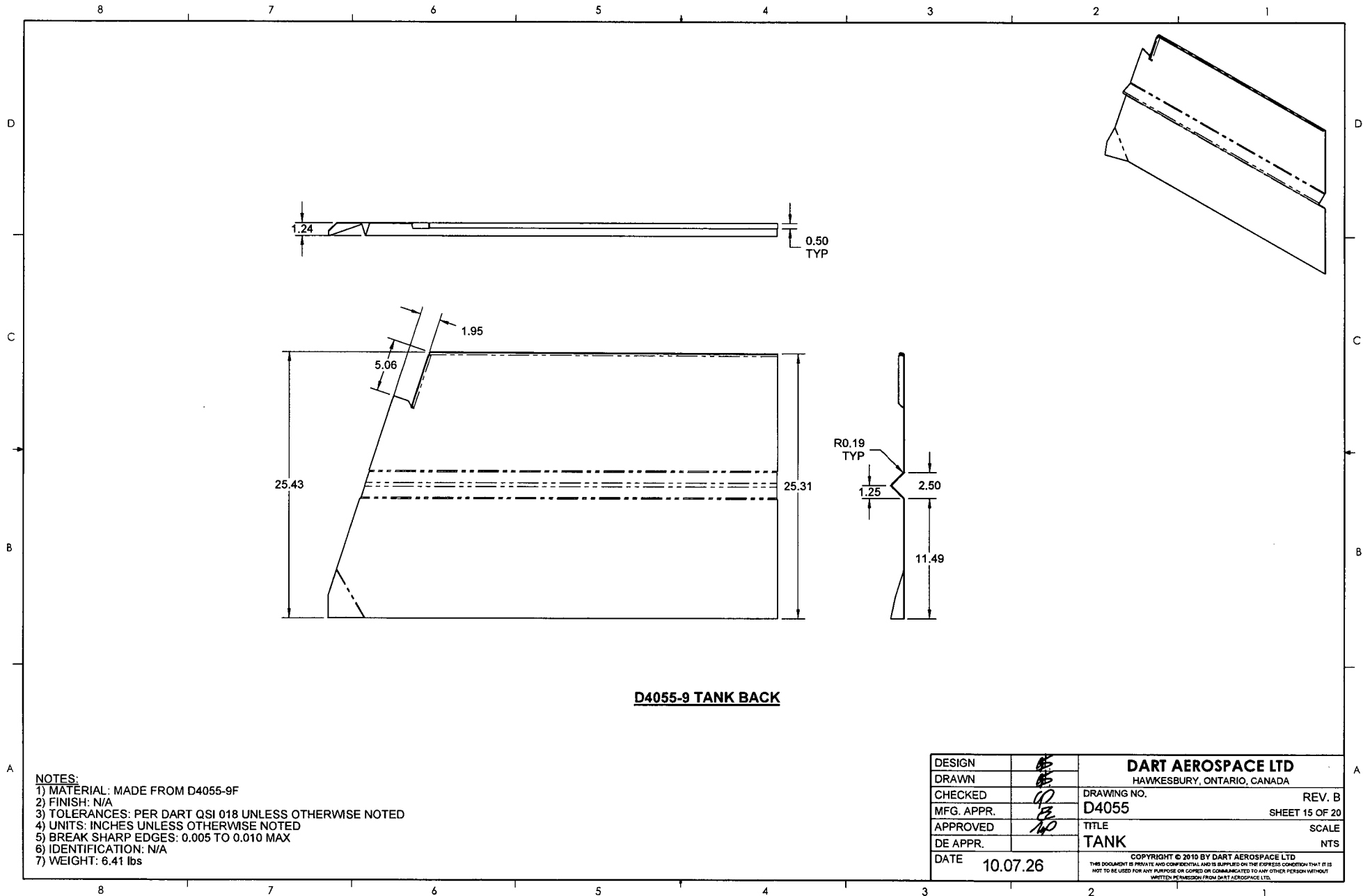
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 20
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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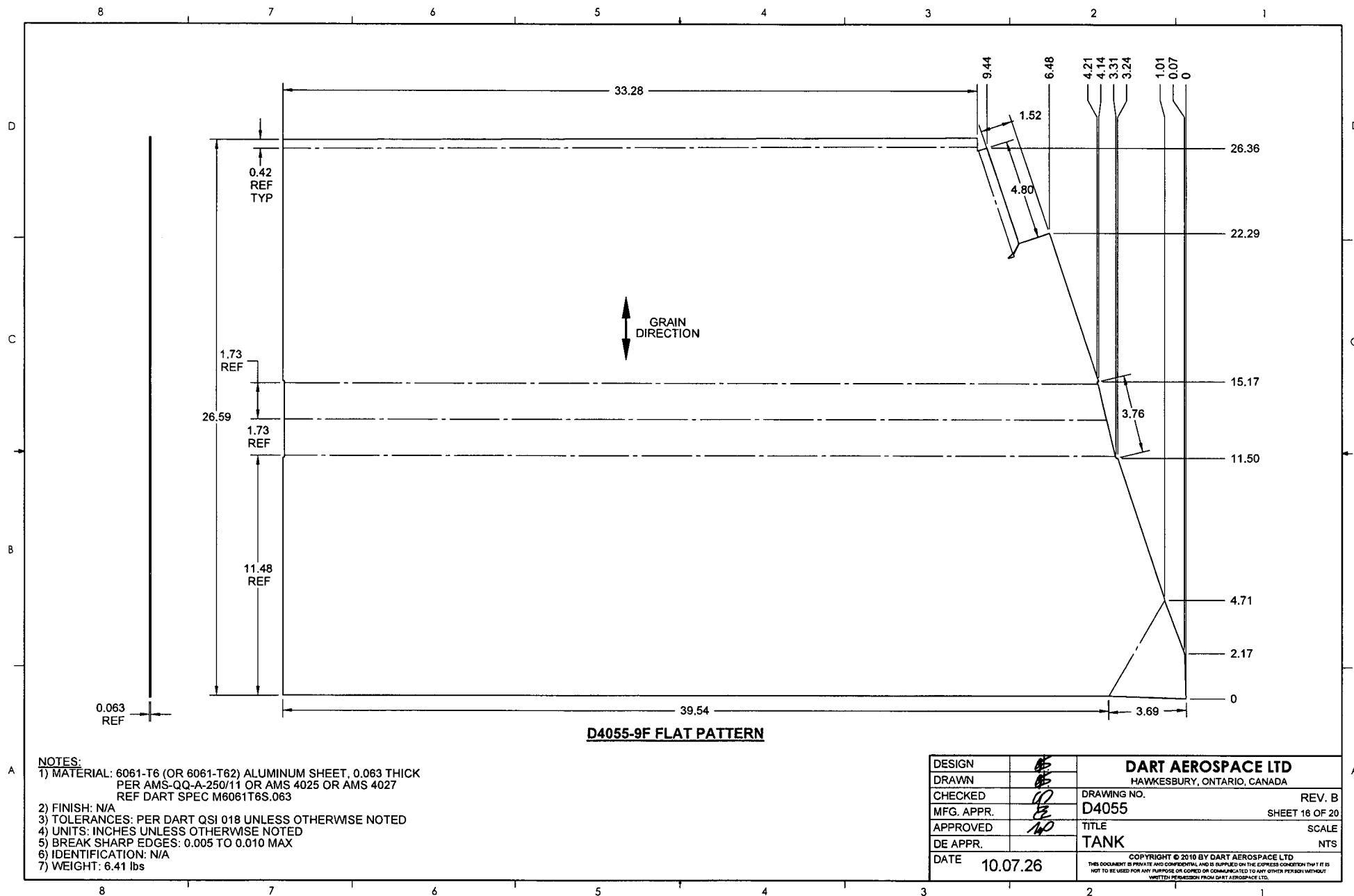




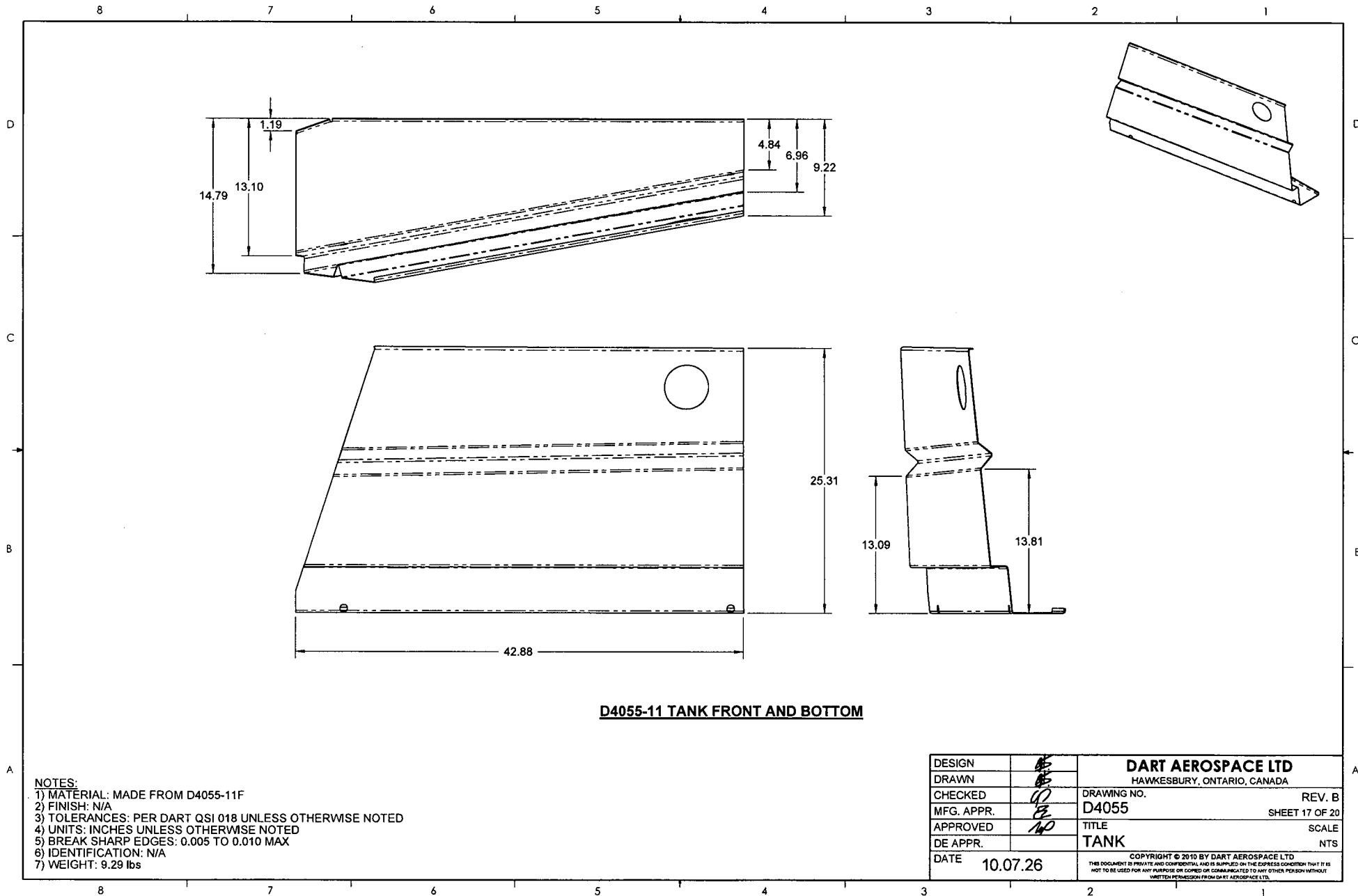
NOTES:

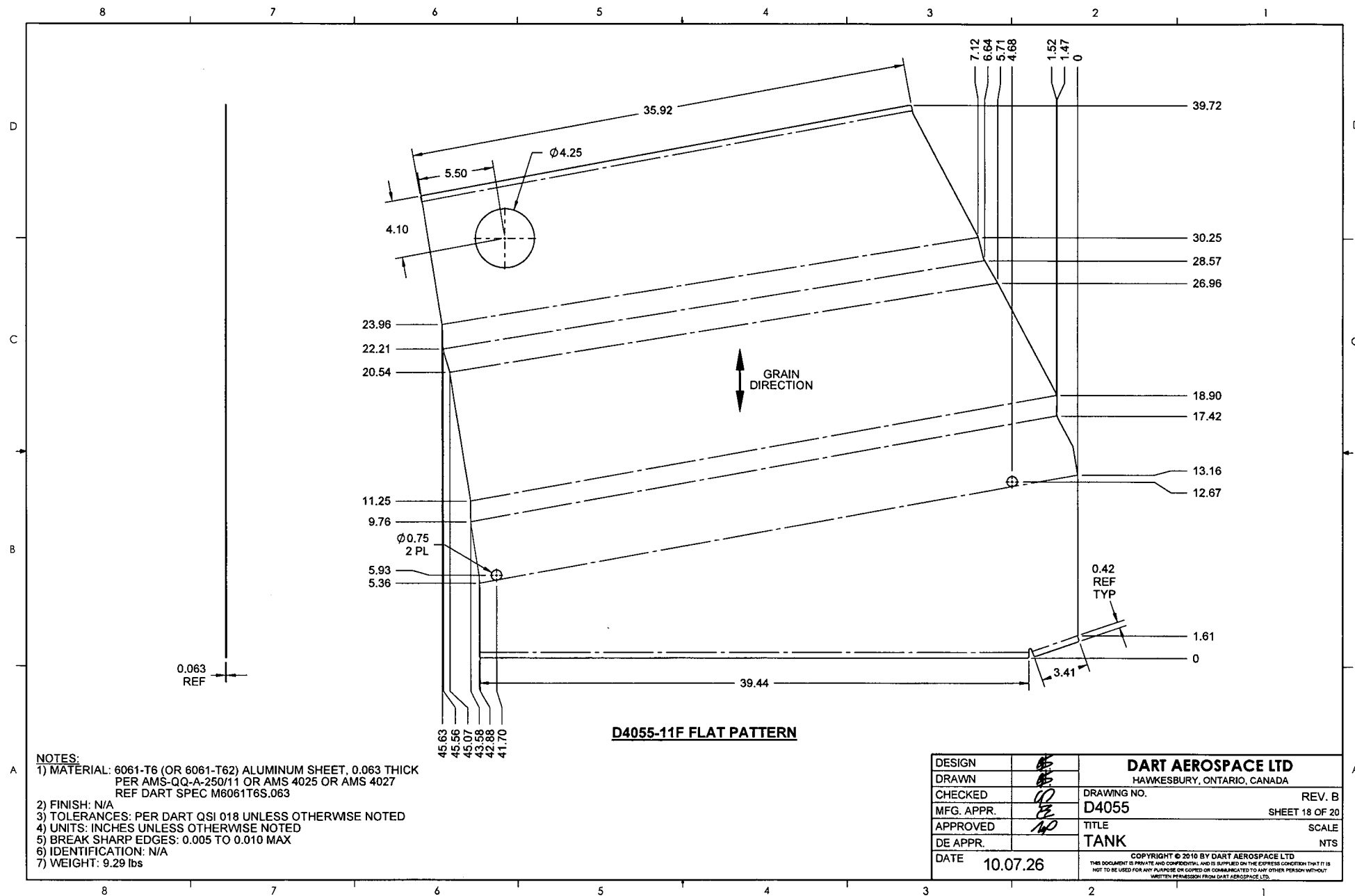
- 1) MATERIAL: MADE FROM D4055-9F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.41 lbs

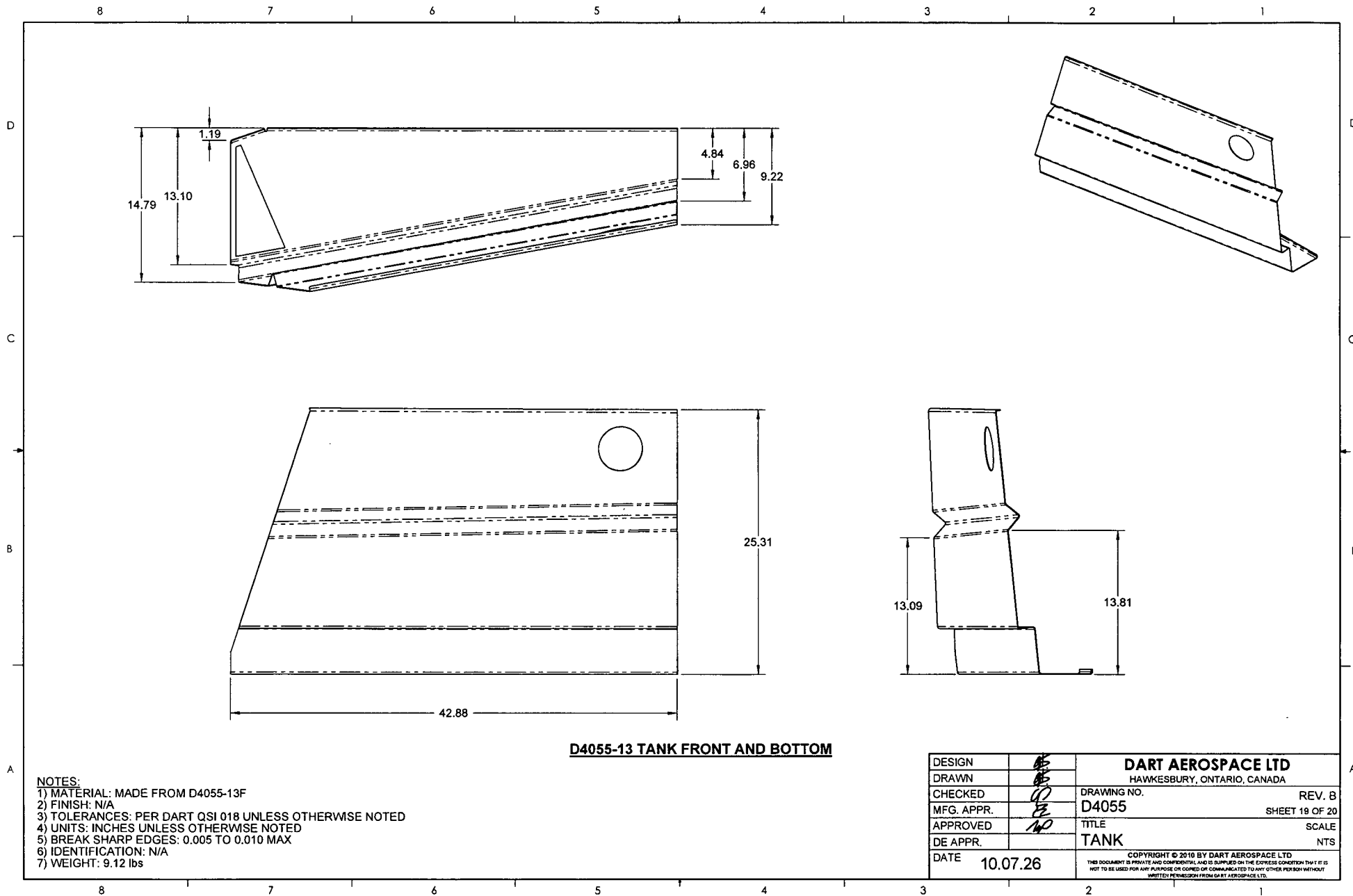
DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AD</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>BE</i>	D4055	SHEET 15 OF 20
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.		TANK	NTS
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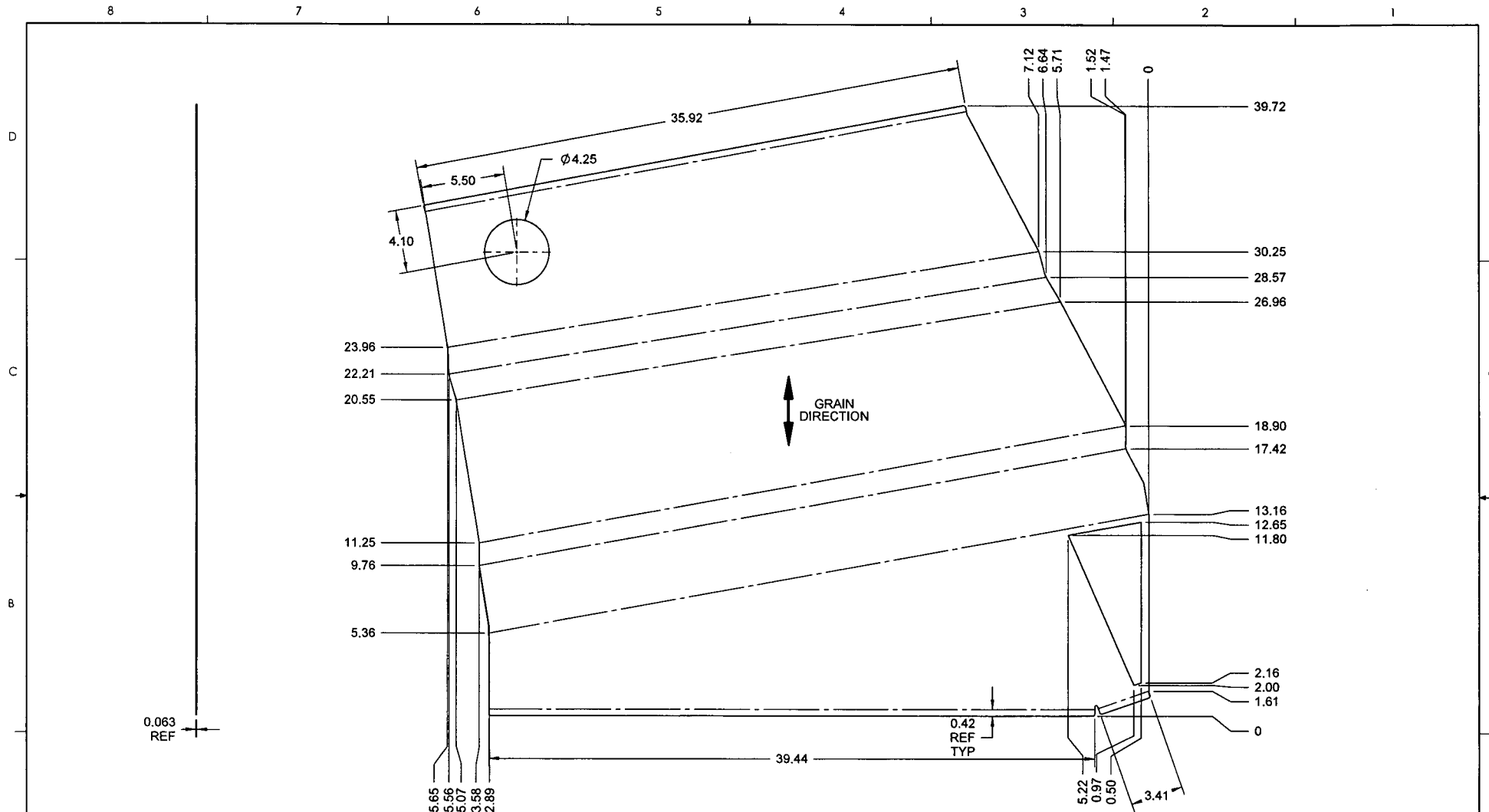


DESIGN	<i>EE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4055 TITLE TANK COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONCOITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	REV. B
DRAWN	<i>EE</i>		SHEET 16 OF 20
CHECKED	<i>DE</i>		SCALE
MFG. APPR.	<i>EE</i>		NTS
APPROVED	<i>NO</i>		
DE APPR.			
DATE	10.07.26		









NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.12 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AD	DRAWING NO.	REV. E
MFG. APPR.	BE	D4055	SHEET 20 OF 20
APPROVED	AD	TITLE	SCALE
DE APPR.		TANK	NTS
DATE	10.07.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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